

Work Order ID 95843

January-21-13 8:03:08 AM

95843

Page 1

Item ID: D2153

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door Prop

Stop

NS2

Start Date: 1/16/13

Start Qty: 24.00

36

~~*24*~~~~*24*~~ 36

Cust Item ID:

Required Date: 1/22/13

Req'd Qty: 24.00

Customer:

Reference:

Approvals:	Process Plan:	<u>CL</u>	Date: 13/01/21	Tooling:	Date:	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2153	Rev A1								
100 *100* Purchasing	PURCHASING Issue P/O: 18873 Gas Spring P/N: SL13-10 (10lb) Possible supplier: Spring Lift Corporation**Note: Do not ship by air****Allow an extra 7 to 10 business days for shipping**Material release note is required	0.00							<u>CL 13/01/21 36</u>
110 *110* Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Ensure Material Release Note is attached	0.00							<u>36x</u> <u>SD</u> <u>B-01-30</u>
120 *120* QC	QC6- Inspect dimensions to drawing Memo Inspect Test Spring is 10lb	0.00	Das 15 2.69	13-130					<u>36</u> <u>Clean</u>

NCR: Yes / No

DQA: Date: 7/1/2013

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order ID 95843

January-21-13 8:03:08 AM

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Page 2

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Accept

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24

Cust Item ID:

Required Date: 1/22/13 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

36x

13/01/13

Small Fab

Memo

0.00

1- Assemble as per Dwg D21532- Remove Spring Lift name and address with
Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sh/B
B-131

36
Cen

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: ST260

0.00

1

36

13-02-01JB

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order ID 95843

95843

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January-21-13 8:03:08 AM

Item ID: D2153

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Prop

Stop

NS2

Start Date: 1/16/13 Start Qty: 24.00

24

Cust Item ID:

Required Date: 1/22/13 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

M15

13-02-01

13-02-01

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date: 10/10/00

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube					General							
					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Secuence Outside Dimensions	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	Other			

Picklist Print

January-21-13 8:03:08 AM

Page 1

Work Order ID: 95843

Parent Item: D2153

Parent Item Name: Door Prop

Start Date: 1/16/13

Required Date: 1/22/13

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516 Washer	NAS1149D0563J	Purchased	No 72			130	Each	2.0000	2	48 72	95	E/S 13/01/31	
				4 M122452									
					Location		Loc Qty						
					ST504		2						
					1069059		2						
D2153P Door Prop		Purchased	No			130	Each	0.0000	1	48	36	E/S 13/01/31	
D3015-3 Locknut		Manufactured	No			130	Each	124.0000	2	48 72	124	E/S 13/01/31	
				Location			Loc Qty						
				ST023			124						
				92381			124						
SL69-BS Ball Stud		Purchased	No			100	Each	138.0000	2	48 72	138	E/S 13/01/31	
				Location			Loc Qty						
				GA			84						
				122176			56						
				123498			28						
				ST397			54						
				118145			54						

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

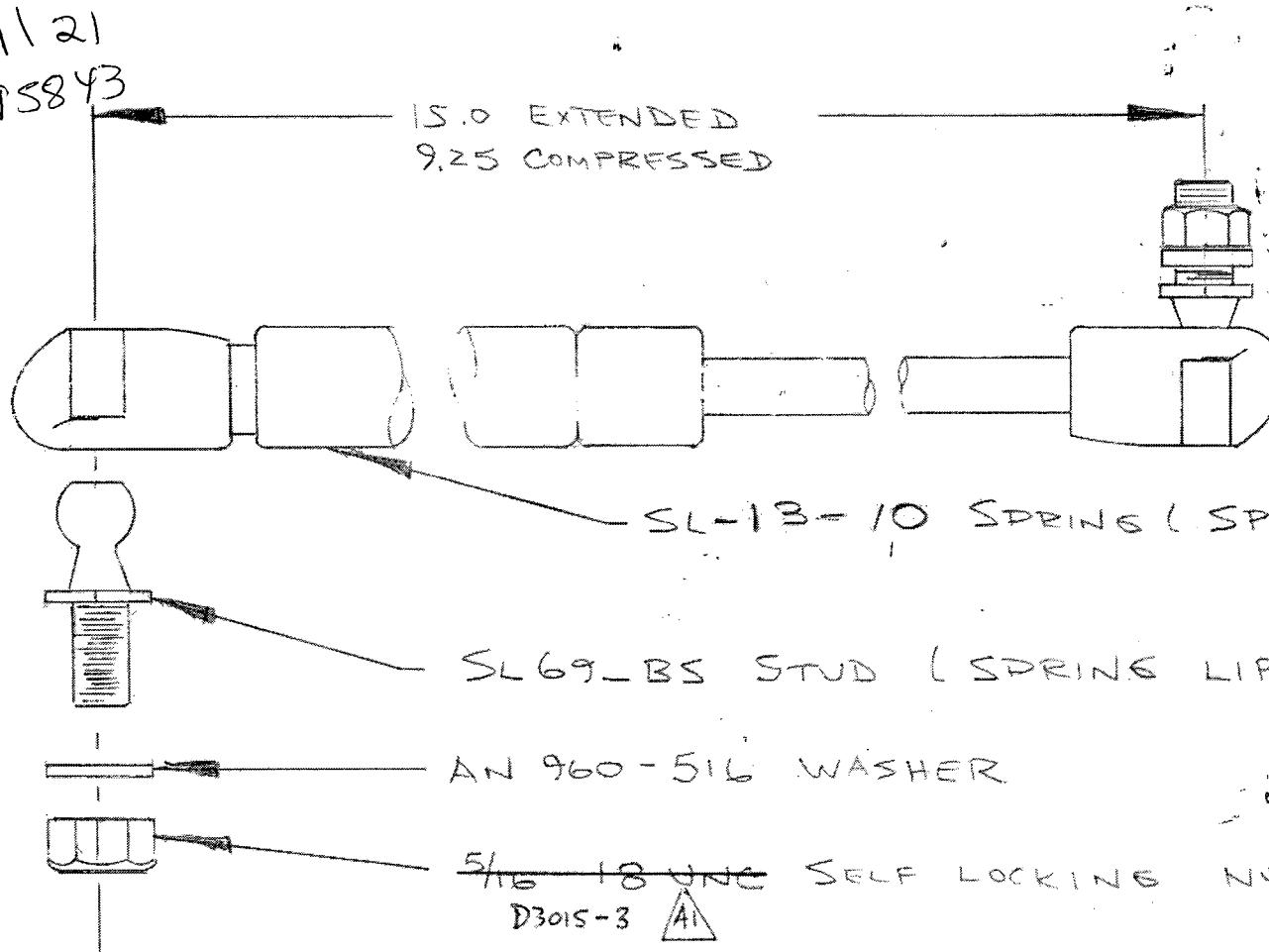
QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS											
Part No. _____	Work Order:	Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
NCR No. _____	Part No. _____	NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>									
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>									
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	<input type="checkbox"/>			Bend	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>			Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>			BOM/Route	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>			Temperature/Cure
Cracks	<input type="checkbox"/>			Broken/Damaged	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>			Weld
Crushed/Crimped	<input type="checkbox"/>			Burrs	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>			Wrong Stock Pulled
Cuffs	<input type="checkbox"/>			Contamination	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>			
Heat Treat	<input type="checkbox"/>			Countersink	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>			
Inspection Strip in Tube	<input type="checkbox"/>			Cut Too Short	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>			
Ripples in Bend	<input type="checkbox"/>			Drill Holes	<input type="checkbox"/>			Offset	<input type="checkbox"/>				<input type="checkbox"/>			
Torque Waves in Extrusion	<input type="checkbox"/>			Drawing	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>				<input type="checkbox"/>			
Turning Sequence	<input type="checkbox"/>			Finish	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>				<input type="checkbox"/>			
Wave/Twist in Tube	<input type="checkbox"/>			Folio	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>				<input type="checkbox"/>			

CD13/01/21

W10: 95843

15.0 EXTENDED
9.25 COMPRESSED



- SL-13 = 10 SPRINGS (SPRING LIFT CORP)

SL 69-B5 STUD (SPRING LIFT CORP)

AN 960-516 WASHER

~~5/18/94~~ 5

D3015-3

SELF LOCKING

卷之三

RELEASED
96/07/16

10233

A1	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
		DRAWN		BASIC CODE	DIA. DASH NO. H=HEAD NEAR SIDE F=HEAD FAR SIDE	ITEM	DESCRIPTION	DART	
		APPROVED				CONTRACT NO.			
REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		D=DIMPLE DGT=DIGIT NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO W=SPOTWELD	DRAWN	DATE				
		GENERAL	UNITS	DESIGN	DETAIL				
DESCRIPTION OF CHANGE		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS: 17.1 3. REMOVE SHARP EDGES. 015 MAX 4. THREADS PER MIL. S. 7742 5. HOLES PER INCH 10287	1. TOLERANCES - .001 .000 .002 .010 2. ANGLES .1° 3. PARALLELISM .0002 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALT MISC CENTRE LINES .005	BASIC CODES B=MS20410AD B=MS20428AD	HAZARD	STRESS	COOK	DMC NO	REV
REPORT ALL DISCREPANCIES - DO NOT SCALE									



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18873**

Purchase Order Date 1/21/13

PO Print Date 1/21/13

Page Number 1 of 1

Order From : VU-ATT001

ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	616-897-2285	Requisition Nbr	
Vendor Fax	616-897-8358	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REvised

FAXED
01/21/13

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2153P	5m Door Prop	1/22/13 Yes	36.00 Each	FedEx PI collect	\$4.1300	\$148.68
2	SL69-BS	Ball Stud	1/22/13 Yes	200.00 Each	FedEx PI collect	\$0.8800	\$176.00

PO Total: \$324.68

CERTIFICATE OF CONFORMITY
RECD UPON DELIVERY

SL B01-30

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required: YES NO

Change Nbr:

2

Change Date: 1/21/13

From:

01/21/2013 09:57

#257 P.001/001

From:

01/21/2013 09:22

#526 P.001/001



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18873

Purchase Order Date 1/21/13

PO Print Date 1/21/13

Page Number 1 of 1

Order From : VU-AT1001
ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

Contract Name
Vendor Phone 616-897-2285
Vendor Fax 616-897-2231
Vendor Account Nbr 616-897-8358
Buyer Chantal Lavoie
Requisition Nbr
Tax Rate Nbr
Terms Net 30
Currency USD
FOB Destination-Collect
- please change

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

List Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Tentative	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	DD153P	Door Prop	1/22/13	36.00 Each	FedEx PI collect	\$4.1300	\$148.68

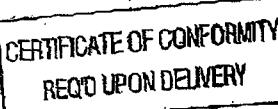
Special Inst: AS PER DWG DD153 REV. A
B95843
PN: SL13-10 (10 LBS) SL13-10-1

2	SL69-BS	Ball Stud	1/22/13	100.00 Each	FedEx PI collect	\$0.8800	\$88.00
---	---------	-----------	---------	-------------	------------------	----------	---------

PO Total: \$236.68

Does not meet \$250 minimum. Please add
Stock or add \$25 fee to waive minimum.

Thanks, Darc



Please advise delivery.

CD

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required YES NO

Change Nbr: 1

Change Date: 1/21/13



TELEPHONE: 616-897-2290

MotorGuide®
NEVER STOP.

CUST: 68580 MST: 08056-00

COLLECT 151793240

PRO NO: 442 10570
SHIP VIA: UPS GROUND
BOL: 00226970003361650BILL TO: DART AERO LTD.
REQ: 01/22/13

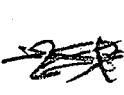
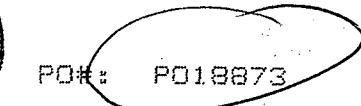
FREIGHT:

F ATTWOOD / MOTORGUIDE
R
D 1016 NORTH MONROE
M LOWELL MI 49331-0260

INCOTERMS: EXW SHIPPER DOCK

SAHS AERO LTD.
T 1270 ABERDEEN STREET
O

HAWKESBURY ON K6A 1K7

CRTS:  PO#:  P018873

WGT: 18 DATE: 01/26/13

SPUR: 6

LABEL NO:

--ROUTING GUIDE INFO --

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART# / UPC	DESCRIPTION / SKU	LN	ORD	QTY	WGT
2	200	W03131	EA	SL69-BS-1	10MM BALL STUD W/THRD	2	200	6	
1	36	W03911	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	1	36	12	

SPB-01-30

Commercial Invoice

ECI

Ship Date:

1/28/2013

International Tracking# : 357742670113639



ACI-357742670113639

Purpose:

Shipper

CO NAME: ATTWOOD CORPORATION

CONTACT: Jeff Jones

ADDR1: 1016 N. MONROE

ADDR2:

CITY: IOWELL

ST/PR: MI

PSTL: 49331 CNTRY: US PH#: 616 897-9241

IRS/EIN:

Food Shipment: N PN/EN:

Broker FedEx Ground's Broker

CO NAME:

CONTACT:

ADDR1:

ADDR2:

CITY:

ST/PR:

PSTL: PH#: CNTRY:

IRS/EIN:

Nbr Pkgs: 1 BOX

Consignee

CO NAME: SAHS AERO LTD.

CONTACT:

ADDR1: 1270 ABERDEEN STREET

ADDR2:

CITY: HAWKESBURY

ST/PR: ON CNTRY: CA

PSTL: K6A1K7 PH#: 6136325200

IRS/EIN:

Importer

CO NAME:

CONTACT:

ADDR1:

ADDR2:

CITY:

ST/PR: CNTRY:

PSTL: PH#:

IRS/EIN:

MARKS/NBRS: HS CODE: 8487900080 CTRY MFG: US

WEIGHT: 0.0 UNIT QTY: 36 EA UNIT VALUE: 4.130000

COMMODITY VALUE: 148.68 USD LICENSE:

EX DATE:

DESCRIPTION: GAS SPRING 15 EXTC 10 BL SCKT

gas spring 15 extension 10 Black socket

MARKS/NBRS: HS CODE: 8302496055 CTRY MFG: US

WEIGHT: 0.0 UNIT QTY: 100 EA UNIT VALUE: 0.880000

COMMODITY VALUE: 88.00 USD LICENSE:

EX DATE:

DESCRIPTION: BRACKET 10MM BALL STUD ~~WTHRD~~ with Threads

gas spring 15 extension 10 Black socket

MARKS/NBRS: HS CODE: 8302496055 CTRY MFG: US

WEIGHT: 0.0 UNIT QTY: 100 EA UNIT VALUE: 0.880000

COMMODITY VALUE: 88.00 USD LICENSE:

EX DATE:

DESCRIPTION: BRACKET 10MM BALL STUD ~~WTHRD~~ with Threads

gas spring 15 extension 10 Black socket

Tracking Numbers

357742670113639

Carrier Code: FDEG

INTERNATIONAL
SHIPMENT NUMBER

141476483

FedEx Ground OP-089 6/07



ACI-357742670113639

TOTAL SHIPMENT WEIGHT:	19 LBS	TOTAL COMMODITY VALUE:	324.68
FREIGHT AMOUNT:	0.00		
INSURANCE AMOUNT:	0.00		
OTHER AMOUNT:	0.00		
TOTAL INVOICE:	324.68		
TERMS OF SALE:	FOB		

These commodities, technology, or software were exported from the United States in accordance with the Export Administration regulations. Diversion contrary to United States is prohibited.

NAME

TITLE

COMPANY

STATUS :EXPORTER : PRODUCER : OF THE CERTIFIED GOODS (Check One)

TELEPHONE : FAX :

COUNTRY OF ORIGIN :

UNITED STATES MEXICO , MEXICO AND UNITED STATES (Check One)

(For purposes of determining the applicable preferential rate of duty as set out in Annex 302.2, in accordance with the marking rules or in each Party's schedule of tariff elimination.)

SIGNATURE : DATE :

COMMENTS:

I declare all information in this invoice to be true and correct.

Jeff Jones

ATTWOOD CORPORATION

1/28/2013



ACI-357742670113639